

# Work Order ID 80193

\*80193\*

Page 1

February-14-12 7:31:42 AM

Item ID: D4092-041

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Maintenance Step Assembly

Start Date: 2/14/12 Start Qty: 3.00

\*2\*

Cust Item ID:

Required Date: 2/15/12 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals: Process Plan: 

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4092

B

100

Pick Kit

0.00

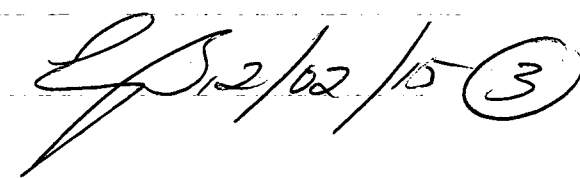
\*100\*

Packaging

Memo

0.00

Packaging

 2/02/15 (3)

110

0.00

\*110\*

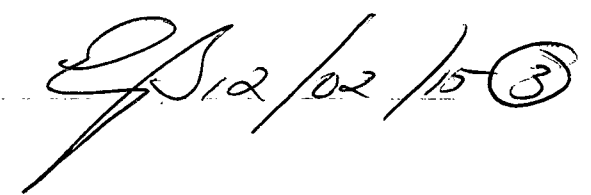
Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg  
Torque screws up to 15-25 in- lbs

 2/02/15 (3)

120

QC5- Inspect part completeness to step on W/O

0.00

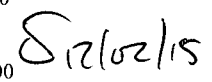
\*120\*

QC

Memo

0.00

Quality Control

 2/02/15

(3)

# Work Order ID 80193

\*80193\*

Page 2

February-14-12 7:31:42 AM

Item ID: D4092-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Maintenance Step Assembly

Start Date: 2/14/12 Start Qty: 2.00 \*2\*

Cust Item ID:

Required Date: 2/15/12 Req'd Qty: 2.00 \*2\*

Customer:

Reference:

Run Start \*NR1\*

Approvals: Process Plan: Date: Tooling: Date:

Stop \*NR2\*

QC: Date: SPC (Y/N): Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

\*130\*

Packaging

Memo

0.00

Packaging

(3) SP 12-02-15

140

QC21- Final Inspection - Work Order Release

0.00

\*140\*

QC

Memo

0.00

Quality Control

M.C.J 12/02/15

12-02-15  
(3)

# Picklist Print

February-14-12 7:31:41 AM

Page 1

2

Work Order ID: 80193

Parent Item: D4092-041

Parent Item Name: Maintenance Step Assembly

Start Date: 2/14/12



Required Date: 2/15/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-06-01 JLM VERIFIED BY:DD  
639 JLM VERIFIED BY:DD

IPP REV:B AS PER ECN 11-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
 D4092-1 Maintenance Step		Manufactured	No			100	Each	1.0000	2	4		2/12/15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST241A		1							
				74303		1							
D4093-1 Bracket		Manufactured	No			100	Each	11.0000	1	2		2/12/15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST124		11							
				77853		11							
D4093-3 Bracket		Manufactured	No			100	Each	3.0000	1	2		2/12/15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST124		3							
				77850		3							
 D4093-5 Bracket		Manufactured	No			100	Each	24.0000	2	4		2/12/15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST124		24							
				74998		4							
				77851		20							
MS24694-S54 Screw		Purchased	No			100	Each	140.0000	2	4		2/12/15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST289A		140							
				120142		40							
				120361		100							

B78234 50

B80085

20

6

# Picklist Print

February-14-12 7:31:41 AM

Page 2

Work Order ID: 80193

Parent Item: D4092-041

Parent Item Name: Maintenance Step Assembly

Start Date: 2/14/12

Required Date: 2/15/12

Start Qty: 2.00

Required Qty: 2.00

MS24694-S55

Purchased

No

100

Each

165.0000

8

16

Screw

Location

Loc Qty

Loc Code

ST289A

165

119307

65

120142

100

MS24694-S56

Purchased

No

100

Each

78.0000

2

4

SCREW

Location

Loc Qty

Loc Code

ST289A

78

104407

28

120142

50

NAS1149D0332J

Purchased

No

100

Each

2,640.0000

12

24

Washer

Location

Loc Qty

Loc Code

ST298

2640

105793

12

110985

4

117087

89

118384

95

119042

440

119717

1000

120644

1000

MS21042L3

Purchased

No

100

Each

4,788.0000

12

24

Nut

Location

Loc Qty

Loc Code

ST300

4788

117441

25

117885

32

118451

5

118927

3

119017

4325

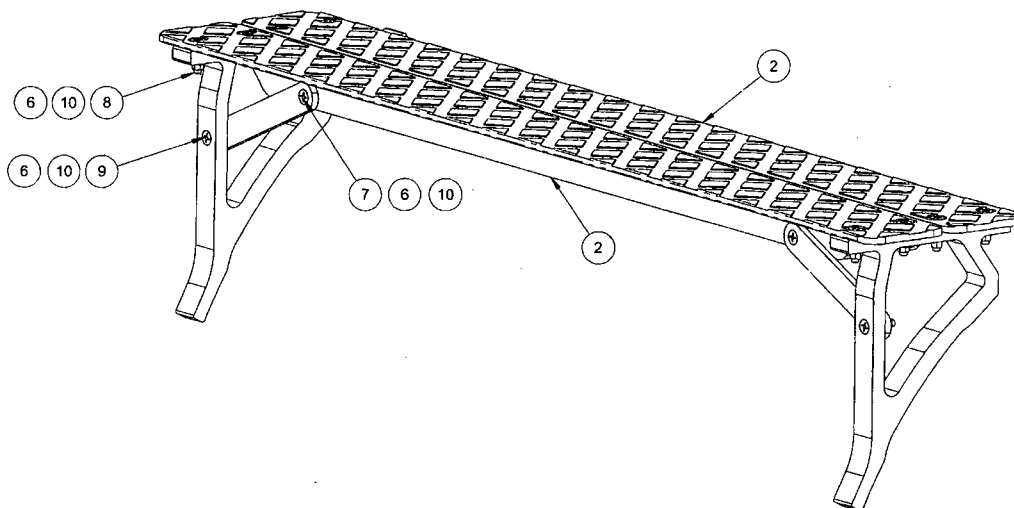
119075

398

February-14-12 7:31:41 AM

Shop Packet Print

Page 2



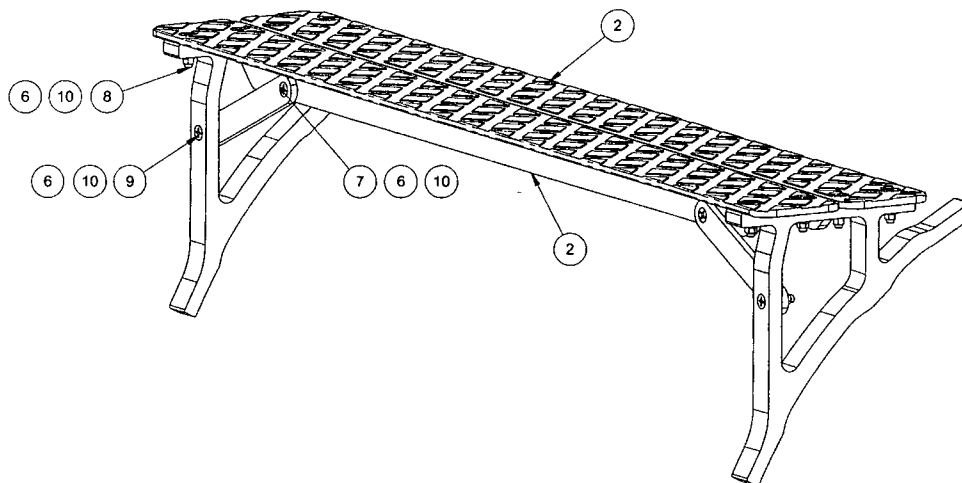
**D4092-041 MAINTENANCE STEP ASSEMBLY**



ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4092-041	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

**RELEASED**  
2011-09-22  
WV

B	REDRAWN: LOWERED FOR AESTHETICS	RF	11.07.27
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	RF		
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	21	D4092	SHEET 1 OF 6
APPROVED	140	TITLE	SCALE
DE APPR.	140	MAINTENANCE STEP ASS'Y	NTS
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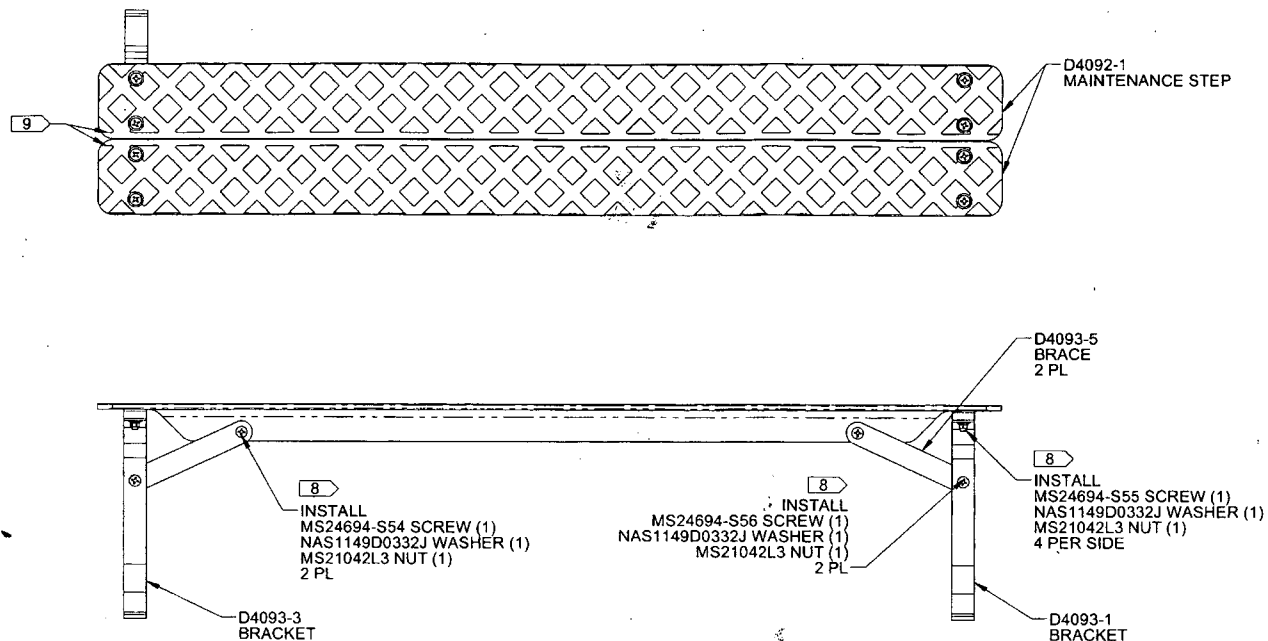
**D4092-042 MAINTENANCE STEP ASSEMBLY**



ITEM	QTY -042	P/N	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACKET
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

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2011-09-22  
JUN

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
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CHECKED	MP	DRAWING NO.	REV. B
MFG. APPR.	ST	<b>D4092</b>	SHEET 2 OF 6
APPROVED	MP	TITLE	SCALE
DE APPR.	ST	<b>MAINTENANCE STEP ASSY</b>	NTS
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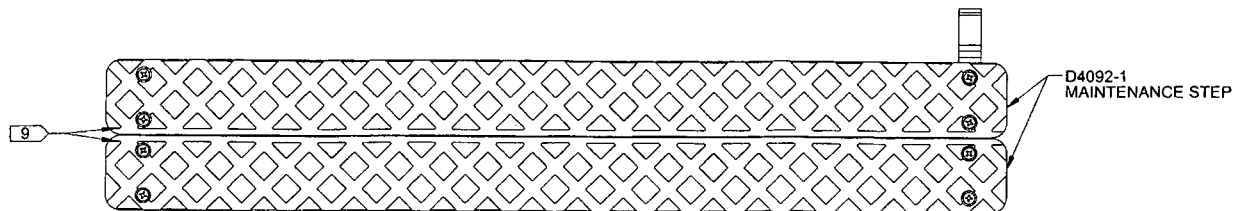
# **D4092-041 MAINTENANCE STEP ASSEMBLY**

## **NOTES:**

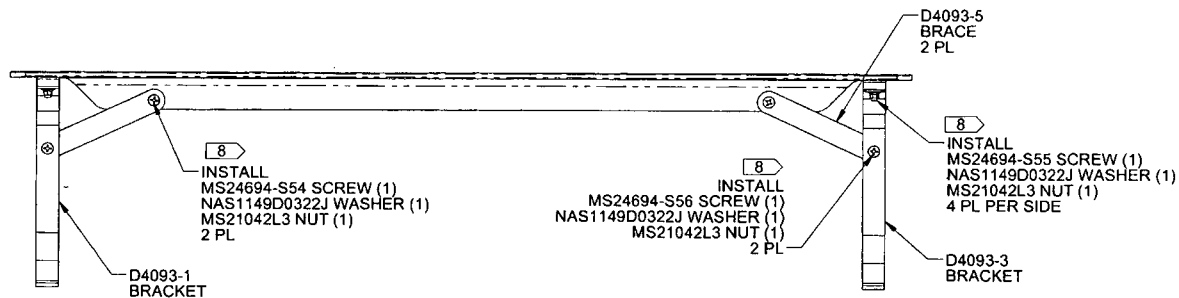
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

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2011-09-22

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MFG. APPR.	RF	D4092	SHEET 3 OF 6
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D4092-1  
MAINTENANCE STEP



8  
INSTALL  
MS24694-S54 SCREW (1)  
NAS1149D0322J WASHER (1)  
MS21042L3 NUT (1)  
2 PL

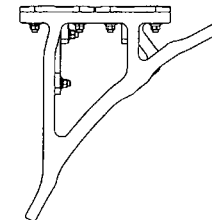
8  
INSTALL  
MS24694-S56 SCREW (1)  
NAS1149D0322J WASHER (1)  
MS21042L3 NUT (1)  
2 PL

D4093-5  
BRACE  
2 PL

8  
INSTALL  
MS24694-S55 SCREW (1)  
NAS1149D0322J WASHER (1)  
MS21042L3 NUT (1)  
4 PL PER SIDE

D4093-3  
BRACKET

D4093-1  
BRACKET



RELEASED  
R 2011-09-22  
JM

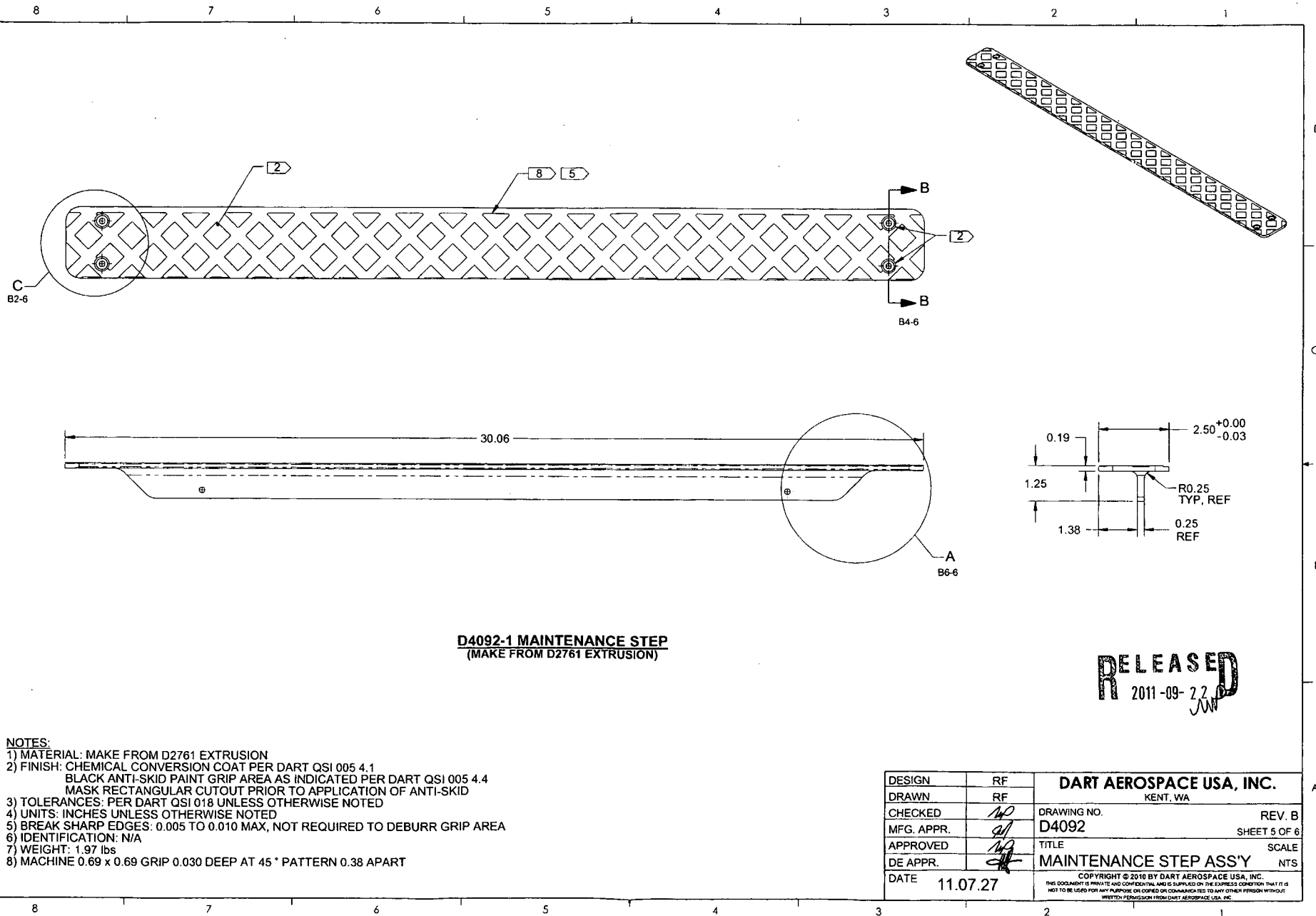
### D4092-042 MAINTENANCE STEP ASSEMBLY

#### NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

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MFG. APPR.	21	D4092	SHEET 4 OF 6
APPROVED	140	TITLE	SCALE
DE APPR.	140	MAINTENANCE STEP ASSY	NTS
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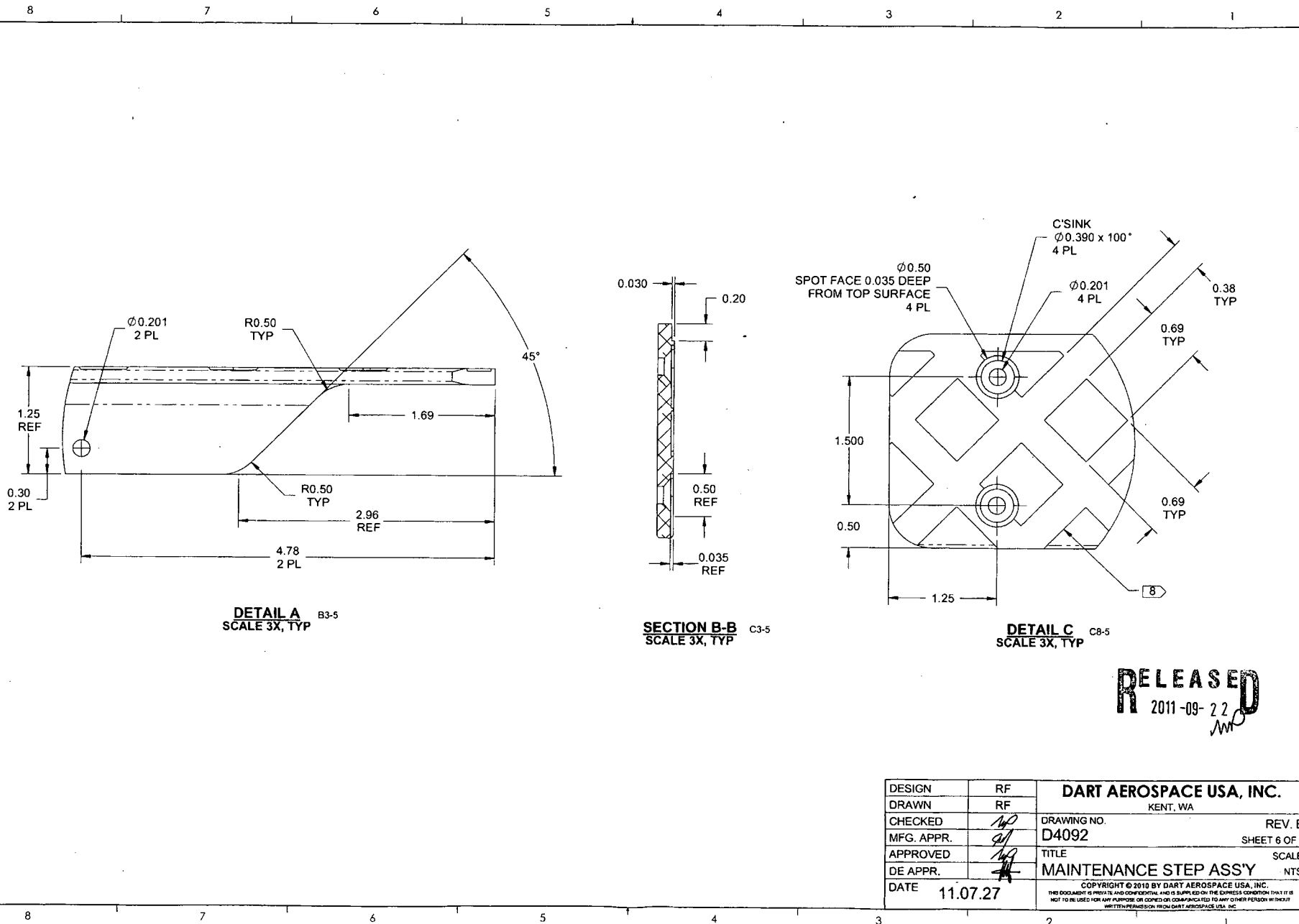
**D4092-1 MAINTENANCE STEP**  
(MAKE FROM D2761 EXTRUSION)

**RELEASED**  
2011-09-22  
JWW

**NOTES:**

- 1) MATERIAL: MAKE FROM D2761 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
BLACK ANTI-SKID PAINT GRIP AREA AS INDICATED PER DART QSI 005 4.4  
MASK RECTANGULAR CUTOUT PRIOR TO APPLICATION OF ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX, NOT REQUIRED TO DEBURR GRIP AREA
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.97 lbs
- 8) MACHINE 0.69 x 0.69 GRIP 0.030 DEEP AT 45° PATTERN 0.38 APART

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MFG. APPR.	<i>MP</i>	<b>D4092</b>	SHEET 5 OF 6
APPROVED	<i>MP</i>	TITLE	SCALE
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2011-09-22  
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MFG. APPR.	<i>[Signature]</i>	SHEET 6 OF 6	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MAINTENANCE STEP ASS'Y	NTS
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